

Work Order ID 82839-2

November-16-12 11:59:47 AM

82839

Page 1

Item ID: D3290-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Window

Start Date: 4/10/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: *u*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3290

Rev C

100

0.00

100

FLOW WATERJET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-cut as per Dwg D3290 Dwg Rev C Prog Rev C 2-
Debur if necessary

12

0

Jm 12-11-16

110

QC 2- Inspect parts off machine 1 MFAIB

0.00

110

QC

Memo

0.00

Quality Control

12

0

Jm 12-11-16

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

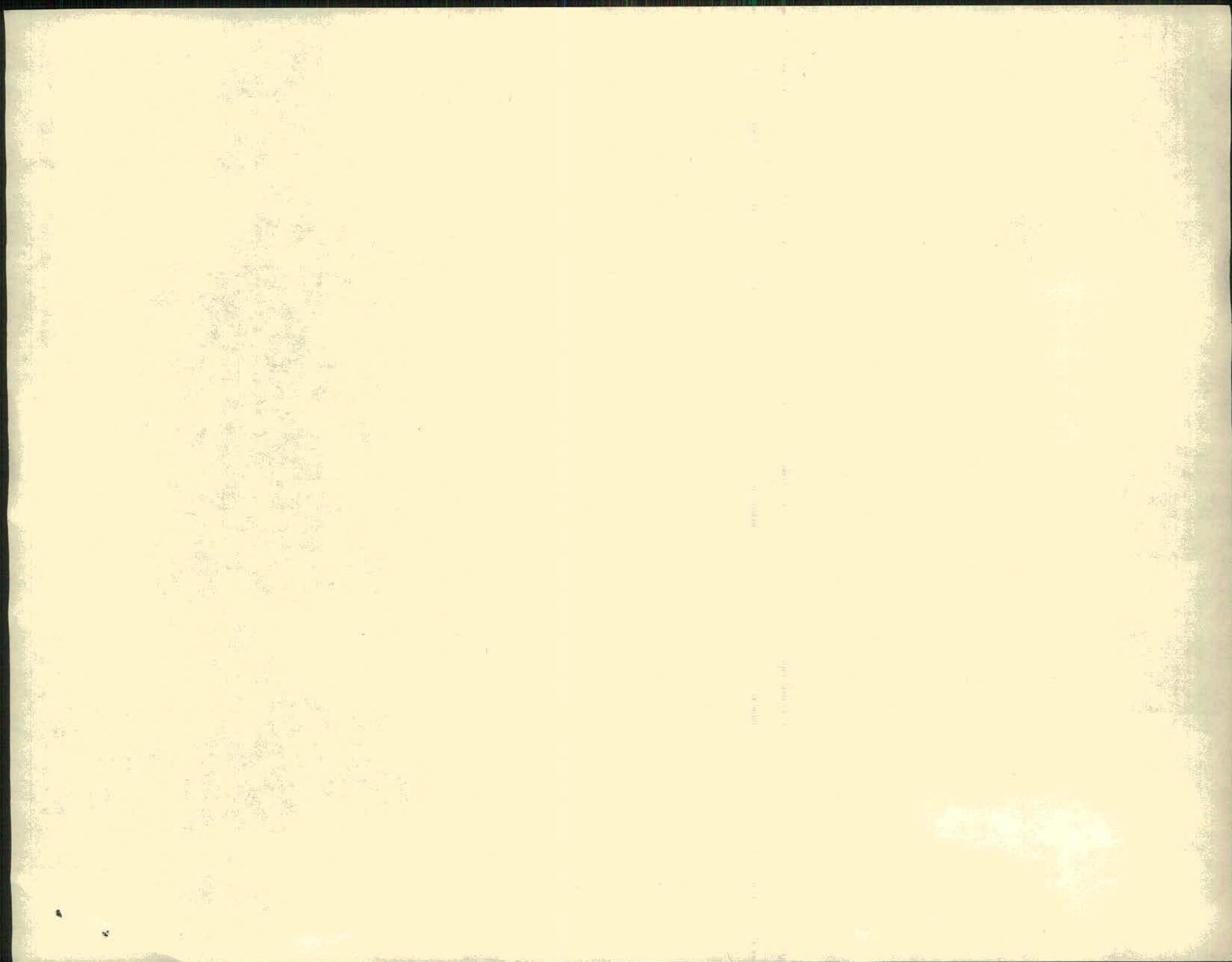
Quality Control

12

13.02.00
where
206 the
balance of
these windows
u

DAD
07
2-03

12/11/19



Work Order ID 82839-1

November-16-12 11:59 47 AM

82839

Page 1

Item ID: D3290-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Window

Start Date: 4/10/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3290

Rev C

100

0.00

100

FLOW WATERJET

Waterjet

Memo:

0.00

FLOW CNC Waterjet

14 out as per Dwg D3290 Dwg Rev C Prog Rev C 2-
Debur if necessary

12

0

Jm 12-11-16

110

QC 2- Inspect parts off machine LATEX

0.00

110

QC

Memo:

0.00

Quality Control

12

0

Jm 12-11-16

120

QC8- Inspect parts - second check

0.00

120

QC

Memo:

0.00

Quality Control

13/02/15

D3290
07
12/11/19



Work Order ID 82839

November-16-12 11:59:47 AM

82839

Page 2

Item ID: D3290-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Window

Start Date: 4/10/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Without removing protective skin remove sharp edge by degurring

13/02/15 17/11/19

140

0.00

140

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-THERMOFORM as per Drawing D3290 and Tolo TPA001 Dwg
Rev. C Tolo Rev. S 2-4 ngrave part &
batch# 13290-31

13/02/15 17/11/19

150

0.00

150

QC2- Inspect parts off machine FAPT AIR

QC

Memo

0.00

Quality Control

13/02/15 17/11/19



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82839

Page 3

Item ID: D3290-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Window

Stop

NS2

Start Date: 4/10/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

170

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

Water sand and buff to remove scratches if required

0.00

0.00

180

180

QC

Quality Control

QC - Inspect part completeness to step on W/O

Memo

0.00

0.00

190

190

Packaging

Packaging

Identify as per dwg & Stock Location

Memo

0.00

0.00

DAS
16

Design for last

w/o 13/2/12

DAS
16

12/1/12

X 3 13/02/15

12/1/12

(2)

x 1

12/1/12

16
200

Work Order ID 82839

November-16-12 11:59:47 AM

82839

Page 4

Item ID: D3290-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Window

Stop *NS2*

Start Date: 4/10/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

200

QC 21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

13/2/2012

~~11/19/12~~

~~12/11/12~~

13-2-20



Picklist Print

November-16-12 11:59:47 AM

Page 1

Work Order ID: 82839
Parent Item: D3290-3
Parent Item Name: Window

Start Date: 4/10/12
Start Qty: 12.00

Required Date: 4/20/12
Required Qty: 12.00

Comments: IPP A04.08.18New issueKJ/RF
IPP B06.05.09Ecn 798 EC IPP Rev. C Removed QC8 Step
160 11/04/11 DL
IPP C 07.05.29 Thermoform in-house DL
IPP D 07.09.28 rev C dwg EC verified by: DD
IPP E 07.11.28 Add --Hand finish deburring DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.125
1/8" Polycast II Sheet

Purchased

No

100

SF

235.8490

3

37.894737
38.0

Inv-11-16

Location

MAT019

Loc Qty

235.849

Loc Code

110633

2

117324

0.2467

117431

10.7967

119591

15.16

121850

46.6456

123704

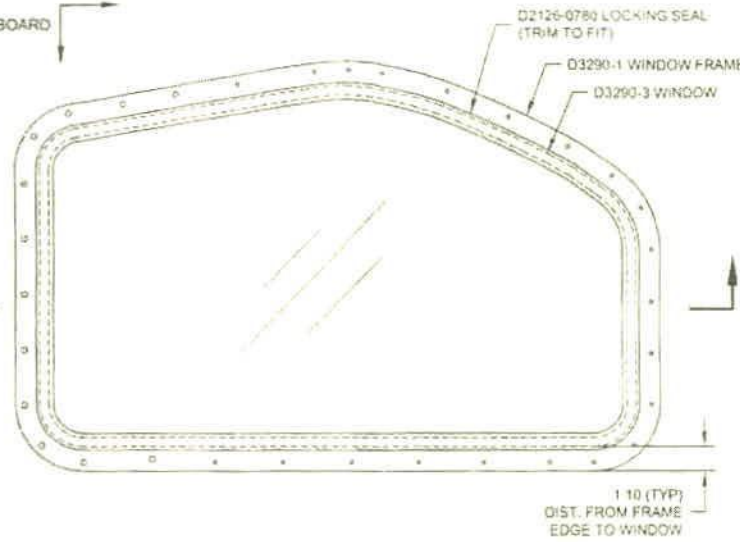
160

23704



1000

FWD
INBOARD

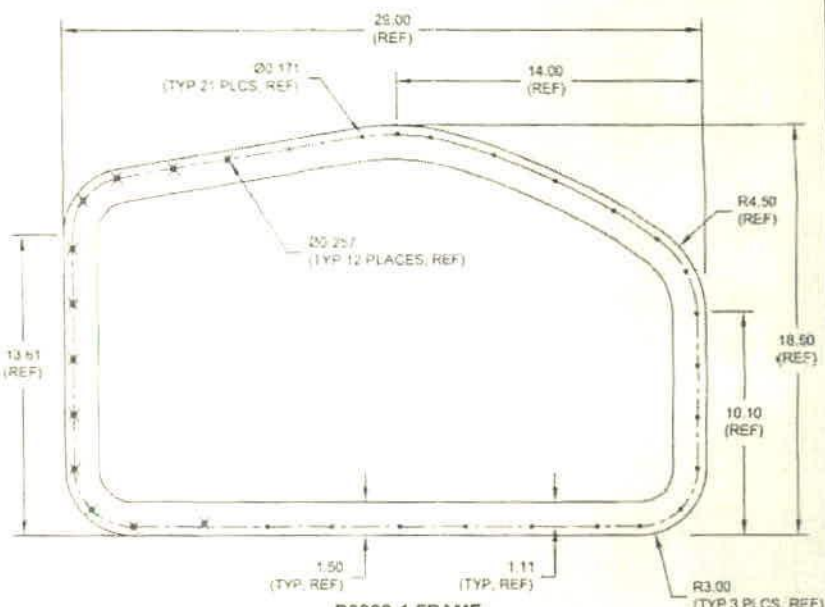


SECTION A-A
NTS

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:
1) TOLERANCES: PER DART QSI 010 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED



- D3290-1 NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052 H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
5) WEIGHT: 0.47 LBS

RELEASED
07.07.24
DEO ATTACHED

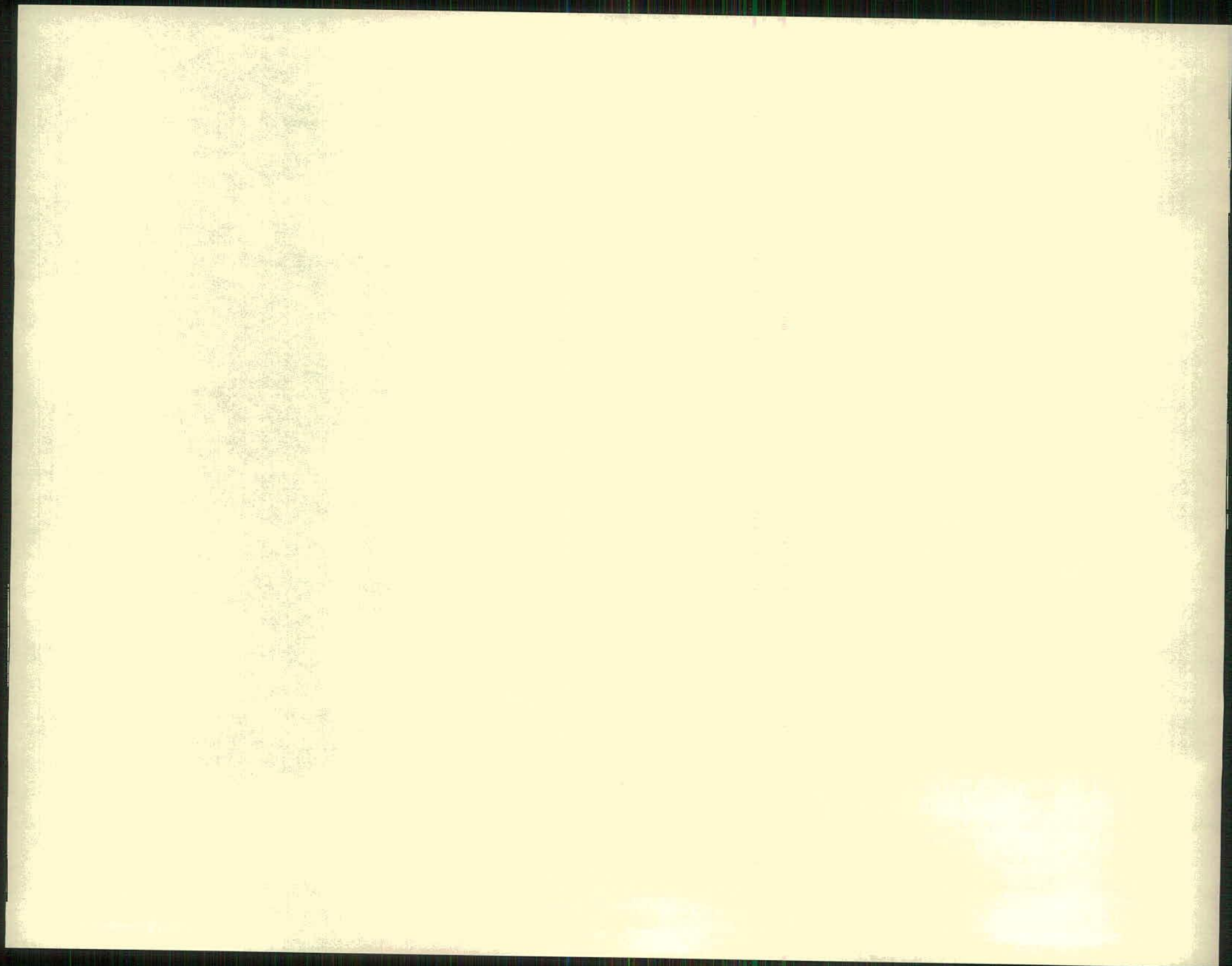
UNDER REVIEW

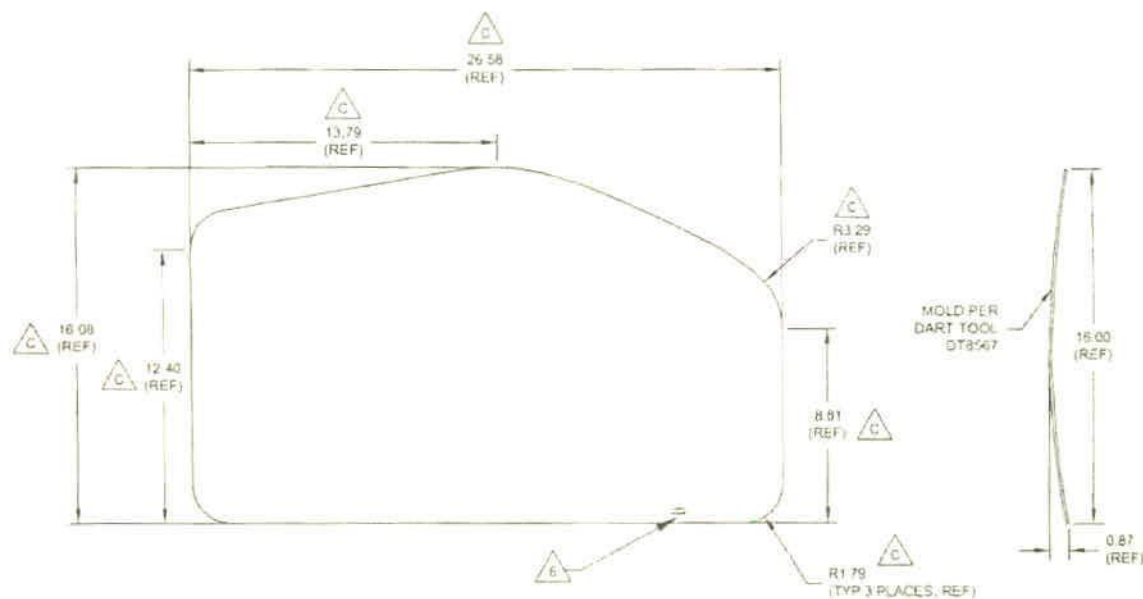
C	UPDATE DIMS PER PARI 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 028	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR			
APPROVED			
DE APPR			
DATE	07.07.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

(DRAWING NO. REV. C
D3290 SHEET 1 OF 2
TITLE SCALE
REPLACEMENT WINDOW ASSEMBLY 1:5

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D3290-3 WINDOW



D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S 125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B.N. ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 ± 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

**DEO ATTACHED
RELEASED**
07.07.24

DESIGN	7-#	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO.	REV. C
MFG APPR	DE	D3290	SHEET 2 OF 2
APPROVED	DE	TITLE	SCALE
DE APPR	DE	REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>h</i>	DE APPR. <i>h</i>			
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21			

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09
W

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